

Thursday, 30/10/2008 1:45:44 PM
User: Julie Dawson

Process Sheet

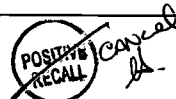
Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL TUNNEL L/H
Job Number : 43096	
Estimate Number : 13585	
P.O. Number :	Part Number : D38221
This Issue : 30/10/2008 S.O. No. :	Drawing Number : D38221 UNDER REVIEW 08.11.10
Prsht Rev. : NC	Project Number : IN0002
First Issue : // Type : R&D THERMOFORMING	Drawing Revision : A UNDER REVIEW
Previous Run : 42067	Material : MKYDEX6185S80P362015
Written By :	Due Date : 06/11/2008 Qty: 2 Um: Each
Checked & Approved By :	
Comment : Est. A New Issue 08/09/17 DL	

PROTOTYPEPLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

30/10/2008 DL

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MKYDEX6185S80P362015 Kydex velour matte, ivory



Comment: Qty.: 7.4028 sf(s)/Unit Total: 14.8056 sf(s)
Kydex velour matte, ivory

M109703

2.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Machine set up

08/11/03 DL

3.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

08/11/03 DL

4.0 THERMOFORMING THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-1 and folio (FTA 9073 Prototype) using tool DT 9073

Dwg. Rev. A UNDER REVIEW
Folio Rev. A

08/11/03 DL

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

08/11/03 DL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL L/H

Job Number: 43096

Part Number: D38221

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



08.11.27 @



Comment: SECOND CHECK

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

08/11/27 (x2)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

08.12.01

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.12.01 Prototype

Job Completion



POSITIVE RECALL

EFFECTIVE 08.10.30

RELEASED

DATE

CANCEL 08.12.01

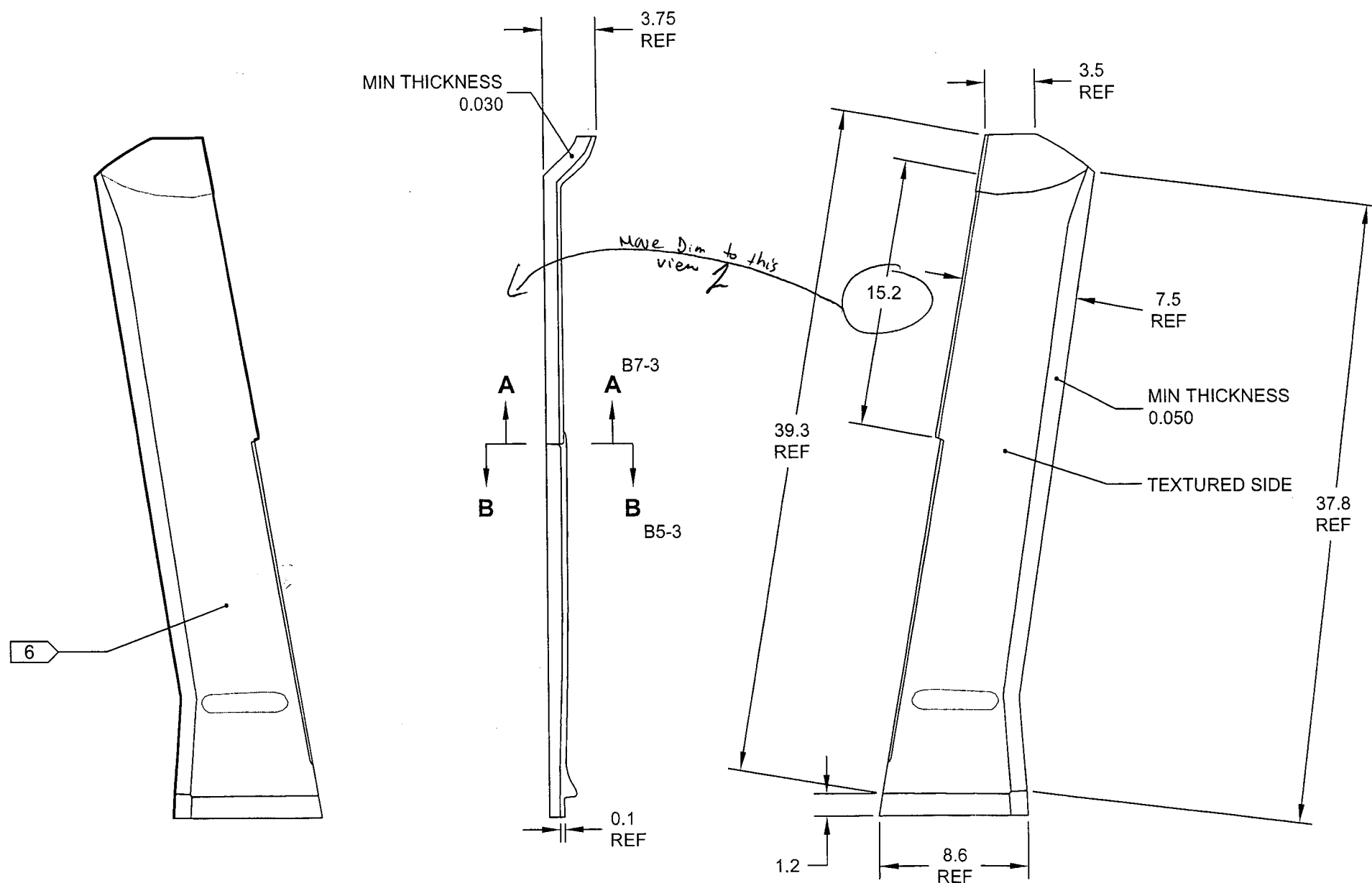
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

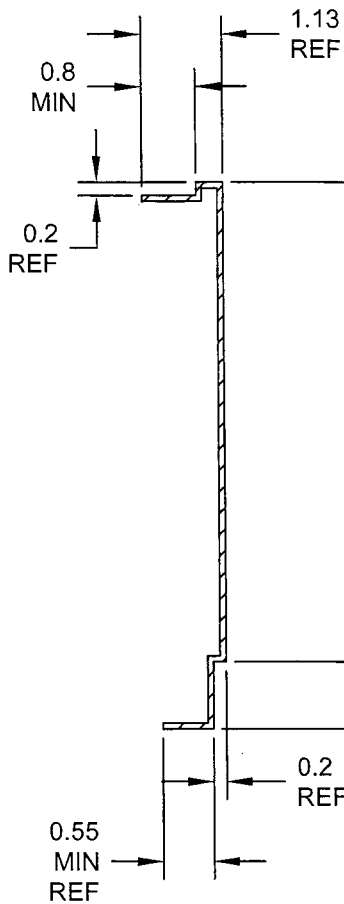


D3822-1 VERTICAL TUNNEL, LH

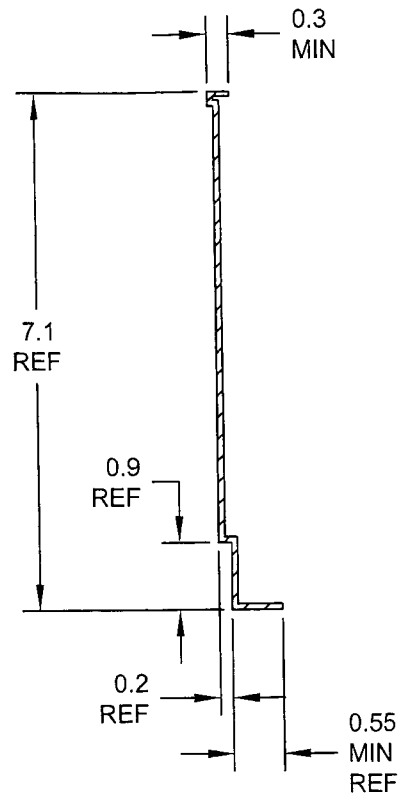
PROTOTYPE
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03.11.10 PLS

- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-1" USING VIBRATING STYLUS
 - 7) WEIGHT: 1.2 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9073 PER DART QSI 022. TRIM PER MOLD.

A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PLS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PLS		
CHECKED	PLS	DRAWING NO.	REV. A
MFG. APPR.		D3822	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL	NTS
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A C6-1



SECTION D-D C4-2

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
03.11.10 *pt*

<i>pt</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
<i>pt</i>	DRAWING NO.	REV. A
<i>pt</i>	D3822	SHEET 3 OF 6
	TITLE	SCALE
	VERTICAL TUNNEL	NTS
4	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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Receiving Report

Date _____

Batch No:

Supplier:

Dart P/O:

Packing Slip:

Yes

No

Invoice:

Yes

No

Receipt:

Cash

Cr

Release Note Attached:

Yes

~~No~~

N/A

Waybill Attached:

Yes

No

Shipment Complete

Yes

No

N/A

QC6 Inspection

N/A

Work Order

N/A

Discrepancies

Discrepancies						
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Fun/Admin:

Location

سابك
sabic

SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

54 800/27

08/01/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER

DART AEROSPACE LTD		Work Order: 43096
Description: Vertical tunnel LH / Prototype		Part Number: D3822-1
Inspection Dwg: D3822 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB

Date: 08/11/27

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.75 (Ref)		3.75	✓			
0.030	Min	0.035	✓			
0.1	± 0.100	0.180	✓			
39.3 (Ref)		39.3	✓			
15.2	± 0.100	15.23	✓			
1.2	± 0.100	1.20	✓			
7.5	± 0.100	7.5	✓			
0.050	Min	0.057	✓			
39.3 (Ref)		39.325	✓			} Should be a controlled dim.
37.8 (Ref)		37.8	✓			
8.6 (Ref)		8.6	✓			

Measured by: JB

Date: 08/11/27

Audited by: [Signature]

Date: 08.11.27

Prototype Approval: [Signature]

Date: 08.12.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	